

Work Order ID 154225

Tuesday, December 06, 2016 2:50:53 PM

154225

Page 1

Item ID: D3847-11

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearpad

Start Date: 12/7/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/12/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: DAB Date: **DEC 07 2016** Tooling: _____ Date: _____
21
QC: -89 Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
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D3847	D
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100

0.00

100

Waterjet

Memo

0.03

FLOW CNC Waterjet

1-Cut as per Dwg D3847

Dwg Rev: DProg Rev: D

2-Deburr if necessary

(4)

Dec 16/12/08

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.01

Quality Control

(4)

Dec 16/12/08

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NR1

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NR2

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Weld per dwg & QSI004 4.5	0.00				4	0	167273	
150 autoweld 1 Automated Welding 1	Memo Weld hardcoat as per dwg A/R 8259 Batch: <u>M135462</u>	0.00							
160	QC5- Inspect part completeness to step on W/O	0.00				4			DAS 38 9-89
160 QC Quality Control	Memo	0.01							DEC 14 2016
170	QC10- Inspect visual per QSI004- ground welds	0.00				4			DAS 38 9-89
170 QC Quality Control	Memo	0.00							DEC 14 2016

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
193		0.00							DAS 41 9-89
193						4			16-12-14
HandFinish	Memo	0.00							
Hand Finishing	APPLY TEXTURE COATING ON TOP CONCAVE SURFACE AS PER DWG								
	TEXTURE COATING BATCH: <u>135403</u>								
196	QC3- Inspect Part Finish	0.00							DAS 38 9-89
196						4			DEC 15 2016
QC	Memo	0.01							
Quality Control									
200	Identify as per dwg & Stock Location: <u>FP-001</u>	0.00							
200						4			16/12/15
Packaging	Memo	0.01							
Packaging	LOCATION ; FP001								

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Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210DAS
21
9-89

DEC 15 2016

QC

Memo

0.07

Quality Control



Picklist Print

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Page 1

Work Order ID: 154225

154225

Parent Item: D3847-11

D3847-11

Parent Item Name: Wearpad

Start Date: 12/7/2016

Required Date: 12/12/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

IPP REV:B

16.03.31 AS PER DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased		No			sf	68.7050		0.712842			

M304S16GA

304/316 Sheet .063

Dec 16 / 12 / 09

Location

Loc Qty

Loc Code

MAT010

68.705

m135377

0.545

m135559

0.85

m135689

4.31

m136036

63

7

DQA: _____ Date: _____

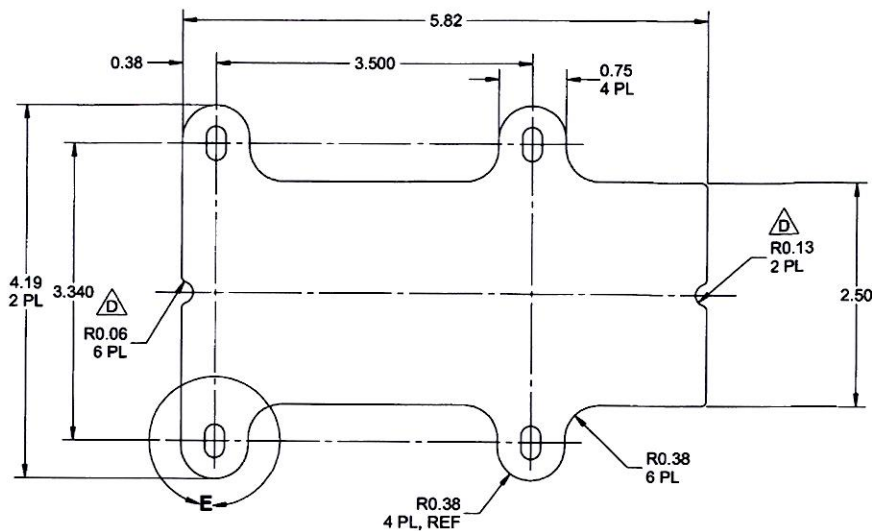


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

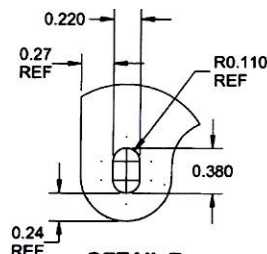
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																		
Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																		
Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐																		
Large Fab ☐	Composite ☐	Supplier ☐																			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																	
Description Work Order Deviation		Disposition																			
				Completed By																	
				Lead hand / Supervisor Approval Verification																	
				QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐																
OTHER :																					

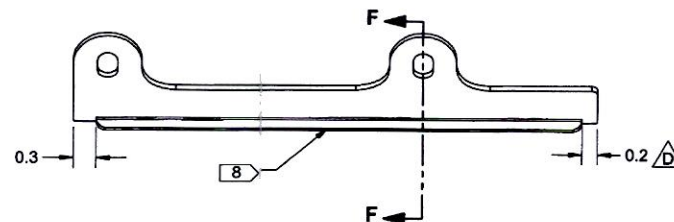


D3847-11F WEARPAD
(FLAT PATTERN)

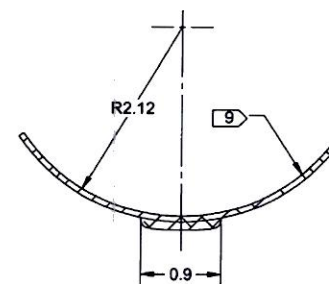
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154225 MWS
16-12-07



DETAIL E
4 PL
SCALE 2X



D3847-11 WEARPAD
(MAKE FROM D3847-11F)



SECTION F-F

NOTES:

- 1) MATERIAL -11F: AISI 304/316 STAINLESS STEEL 16 GAUGE 0.063 THICK
PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.43 lbs
- 8) BUILDUP HARD SURFACING 0.17 TO 0.20 THICK USING 8259 ROD PER QSI 004 SECTION 4.5 (AUTOMATED WELDING) OR
BUILDUP HARD SURFACING 0.19 TO 0.25 THICK USING 2059B ROD PER QSI 004 SECTION 4.1 (MANUAL WELDING)
- 9) COAT ENTIRE TOP (CONCAVE) SURFACE WITH TEXTURED COATING 0.02-0.04 THICK; PER DART QSI 005 4.9

RELEASED
2016-03-31

APPROVED

DESIGN	RF
DRAWN	AJS
CHECKED	ML
MFG. APPR.	DD
APPROVED	WM
DE APPR.	DS
DATE	15.09.28

DART AEROSPACE USA, INC.
EUGENE, OR

DRAWING NO. **D3847** REV. D
SHEET 2 OF 7
TITLE **WEARPLATE ASSY** SCALE NTS

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